



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/03/05  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/25/2006 1:22:07 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 25620

Part Number: D2574

Job Number:



Seq. #: Machine Or Operation:

Description :

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

EP 06/03/09

12

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

MS 06/03/09

12

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SAP 06/03/12

12

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 06/03/14

12

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

DC 06/03/14

12

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 480

c 06/03/15

12

10.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

D 06/03/15

12

Job Completion



U 06/03/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	25620
Description: Saddle, Aft Inboard				Part Number:	D2574
Inspection Dwg: D2574 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.438	0.438	0.438	0.438		
B	1.745	1.755		1.746	1.746	1.746	1.746		
C	3.495	3.505		3.498	3.496	3.497	3.496		
D	1.745	1.755		1.746	1.746	1.746	1.746		
E	7.990	8.010		8.004	8.006	8.005	8.004		
F	0.490	0.510		0.502	0.498	0.500	0.499		
G	0.257	0.262	DT8683	0.257	0.257	0.257	0.257		
H	0.375	0.380	DT8684	0.375	0.375	0.375	0.375		
I	0.490	0.510		0.499	0.500	0.501	0.499		
J	1.174	1.184		1.176	1.178	1.177	1.177		
K	0.558	0.578		0.567	0.567	0.567	0.567		
L	1.174	1.184		1.176	1.178	1.177	1.177		
M	1.365	1.375		1.369	1.368	1.368	1.368		
N	2.495	2.505		2.498	2.497	2.495	2.495		
O	4.119	4.129		4.121	4.122	4.122	4.121		
P	0.115	0.135		0.124	0.124	0.126	0.120		
Q	0.115	0.135		0.130	0.130	0.130	0.130		
R	0.240	0.260		0.252	0.252	0.253	0.247		
S	0.115	0.135		0.127	0.128	0.131	0.131		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.236	3.230	3.230	3.230		
V	0.230	0.250		0.239	0.236	0.240	0.237		
W	0.115	0.135		0.123	0.124	0.125	0.125		
X	0.307	0.312		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.360	0.360	0.366	0.366		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.625	0.624	0.627	0.624		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.250	0.249	0.244	0.247		
AE	1.500	1.520		1.510	1.510	1.512	1.505		
AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.260	0.260	0.266	0.260		
AH	0.240	0.260		0.252	0.252	0.254	0.252		
AI	2.000	2.020		W/LA	W/LA	W/LA	W/LA		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	EN	Audited by:	M8
Date:	06/07/06	Date:	06/03/06

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD				Work Order:	25620
Description: Saddle, Aft Inboard				Part Number:	D2574
Inspection Dwg: D2574 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	0.438	0.438	0.438	0.438		
B	1.745	1.755		1.746	1.746	1.746	1.746		
C	3.495	3.505		3.496	3.496	3.496	3.496		
D	1.745	1.755		1.746	1.746	1.746	1.747		
E	7.990	8.010		8.006	8.004	8.001	8.002		
F	0.490	0.510		0.499	0.499	0.500	0.501		
G	0.257	0.262	DT8683	0.257	0.257	0.257	0.257		
H	0.375	0.380	DT8684	0.375	0.375	0.375	0.375		
I	0.490	0.510		0.500	0.506	0.502	0.502		
J	1.174	1.184		1.177	1.177	1.177	1.177		
K	0.558	0.578		0.566	0.567	0.567	0.568		
L	1.174	1.184		1.177	1.177	1.177	1.177		
M	1.365	1.375		1.368	1.368	1.368	1.368		
N	2.495	2.505		2.495	2.495	2.495	2.499		
O	4.119	4.129		4.121	4.122	4.122	4.122		
P	0.115	0.135		0.123	0.124	0.123	0.123		
Q	0.115	0.135		0.130	0.130	0.130	0.130		
R	0.240	0.260		0.250	0.252	0.251	0.250		
S	0.115	0.135		0.131	0.128	0.129	0.129		
T	0.178	0.198		0.180	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.238	0.244	0.244	0.245		
W	0.115	0.135		0.127	0.126	0.125	0.124		
X	0.307	0.312		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.362	0.366	0.366	0.366		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.626	0.625	0.627	0.626		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.251	0.250	0.254	0.253		
AE	1.500	1.520		1.508	1.510	1.508	1.507		
AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.260	0.260	0.260	0.266		
AH	0.240	0.260		0.248	0.254	0.251	0.249		
AI	2.000	2.020		W14	W14	W14	W14		
AJ	0.023	0.043		0.020	0.030	0.030	0.030		
Accept/Reject									

Measured by:	S.G.	Audited by:	S.G.
Date:	06/03/07	Date:	06/03/07

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

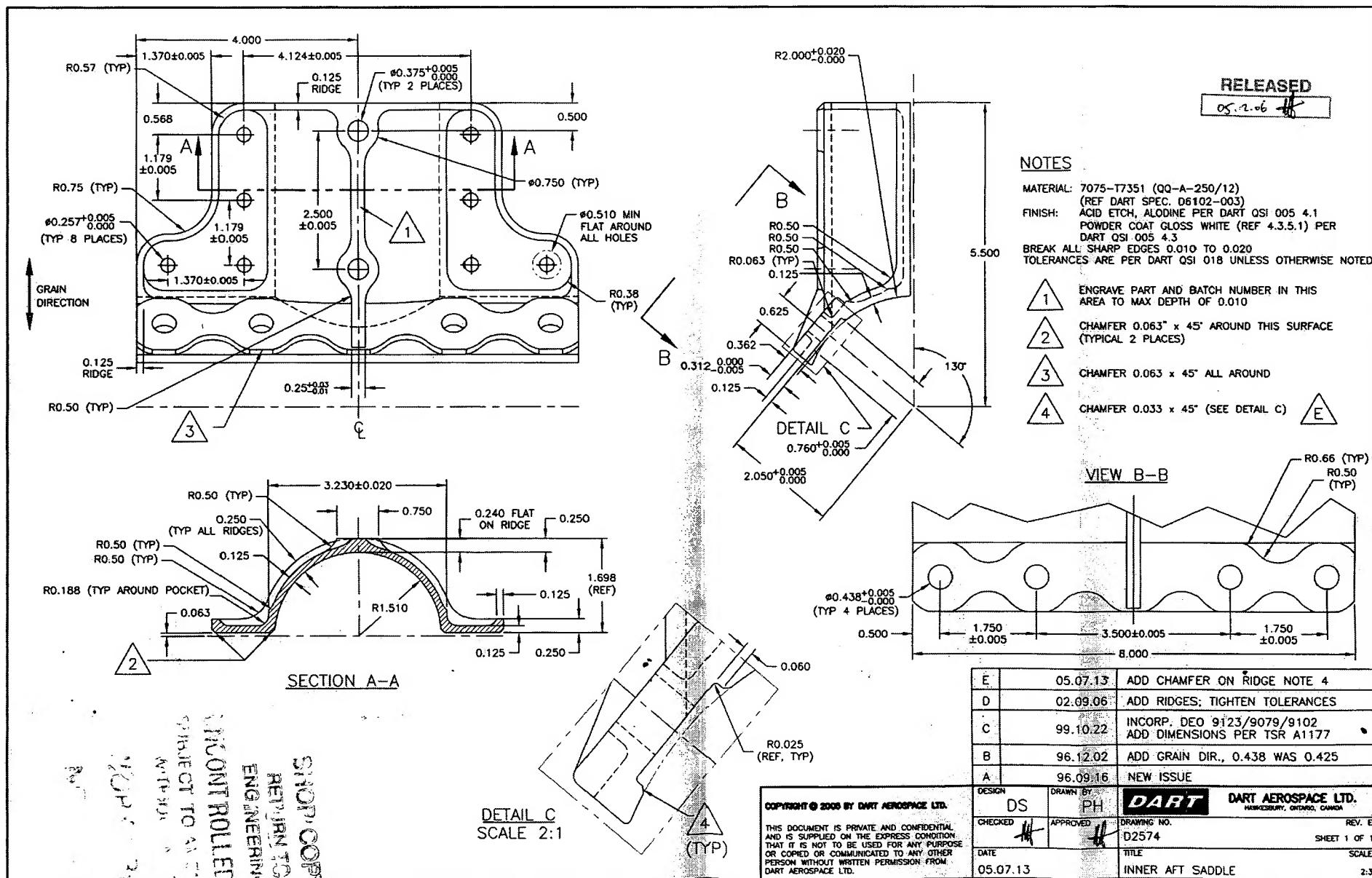
DART AEROSPACE LTD				Work Order:	25620
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Inspection Dwg: D2574 Rev. E				Page 1 of 1	

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B	1.745	1.755		1.747	1.747	1.747	1.747		
C	3.495	3.505		3.502	3.501	3.502	3.501		
D	1.745	1.755		1.747	1.747	1.747	1.747		
E	7.990	8.010		8.002	8.003	8.002	8.004		
F	0.490	0.510		0.501	0.501	0.502	0.498		
G	0.257	0.262	DT8683	0.257	0.257	0.257	0.257		
H	0.375	0.380	DT8684	0.375	0.375	0.375	0.375		
I	0.490	0.510		0.500	0.500	0.504	0.501		
J	1.174	1.184		1.177	1.177	1.177	1.177		
K	0.558	0.578		0.568	0.568	0.568	0.568		
L	1.174	1.184		1.177	1.177	1.177	1.177		
M	1.365	1.375		1.373	1.372	1.378	1.372		
N	2.495	2.505		2.499	2.499	2.500	2.499		
O	4.119	4.129		4.122	4.122	4.122	4.122		
P	0.115	0.135		0.130	0.129	0.123	0.125		
Q	0.115	0.135		0.130	0.130	0.130	0.130		
R	0.240	0.260		0.245	0.244	0.251	0.257		
S	0.115	0.135		0.127	0.126	0.127	0.129		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.220	3.220	3.230	3.230		
V	0.230	0.250		0.239	0.239	0.241	0.237		
W	0.115	0.135		0.130	0.130	0.121	0.121		
X	0.307	0.312		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.362	0.361	0.360	0.360		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.625	0.625	0.626	0.626		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.250	0.251	0.250	0.248		
AE	1.500	1.520		1.509	1.507	1.508	1.508		
AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.249	0.249	0.251	0.252		
AI	2.000	2.020		W14	W14	W14	W14		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	S.G.	Audited by:	ED ..
Date:	06/03/07	Date:	06/03/07

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